

Aero Design Ltd.**Work Order Control Sheet****Work Order#:** 2016-14 **Date Opened:** 18 Jan 16 **Title:** Fabrication**Aircraft OEM:** Bell **Aircraft Model:** 206B/L/407 **Product Type:** Curved Washer **Product Model:** 95228-01 **Quantity:** 235**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

N/A
N/A
JC
JC
N/A
N/A
N/A
N/A

CREATED
JC**Component Completion**

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

235
0
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A
JC
JC
N/A
JC

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

N/A
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
95228	1	Curved Washer	JC

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC
N/A
N/A

Traveller

Initial or N/A

Work performed by:

Print: Dave MartynSign: [Signature]SCA: AD05Date: 18-Jan-16

ICC / Dual Inspection performed by:

Print: Jason RekveSign: [Signature]SCA: AD01Date: 18-Jan-16

Work Order closed by:

Print: Jeff ClarkeSign: [Signature]SCA: AD02Date: 18-Jan-16

Approved Manufacturing Facility 73-04

Form 2010.03

Rev. Original 23 Sep 2014

WO 2016-14

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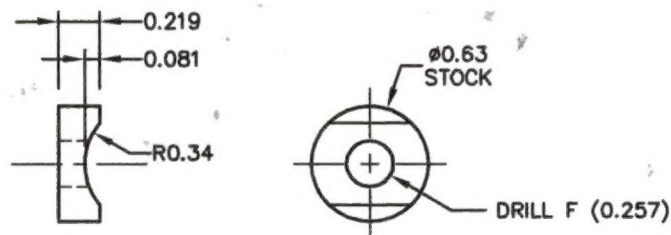
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED	BJC	14/10/2013

NOTES


1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

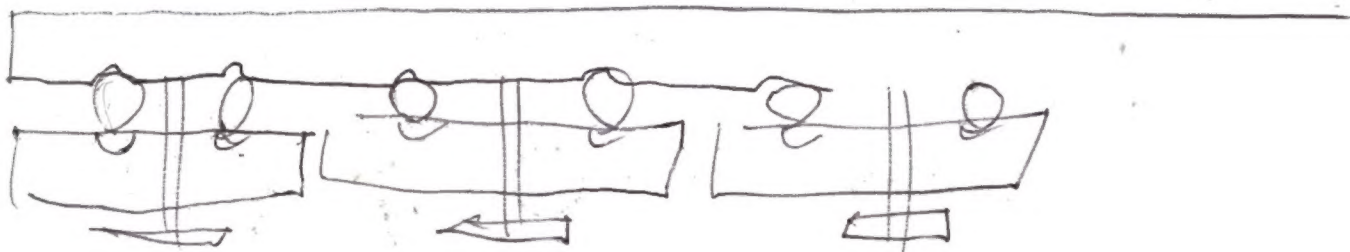
235 parts made

PO# 15048



① CURVED WASHER

		95228-01		01	CURVED WASHER	DELTRIN (BLACK)		COMMERCIAL		#0.625 ROD			
01	PART NO.		ITEM	DESCRIPTION		MATERIAL		MATERIAL SPEC		STOCK SIZE			
QTY		LIST OF MATERIALS											
						APPROVALS		DATE		 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.483.2376 www.aerodesign.ca			
						DRAWN: JEFF CLARKE		18 OCT 2012					
						CHECKED: E. BURGON		18 OCT 2012					
						UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1				BELL 206A, 206B, 206L SERIES, 407 CYCLIC FRICTION REPLACEMENT PARTS - CURVED WASHER			
						SCALE 1 : 1		DWG. SIZE		DWG. NO.		REV.	
						SHEET 1 OF 1		A4		95228		1	



*-078"





WO# 2016-14

Approved Manufacturing Facility 73-04

Form 20.F.06

Rev. Original 27 May 2013

- 5" collet in lathe
- 1380 RPM
- 2.5" stick out, set parting tool with tape measure.
- drill "F" 2" deep, no need for center drill.
- Face off end with parting tool.
- Set B Carriage dial onto any #.
- Turn carriage toward head stock .300"
- Partial part, then de-burr edges, then complete part. (use triangle mini file for deburring). (you get 7 per 2.5 inches of material)


- Milling Curved Washers

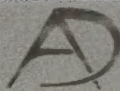
- de-burr bottom end bore of washer and place in fixture with large burr facing up.
- fill all ten spots
- finger tighten allen bolts and place fixture in vise with screws facing operator (make sure vise is aligned).
- tighten screws 1/4 turn then tap with plastic hammer all ten parts, confirm they are flush with top of fixture.
- Finish snugging up bolts 1/8 to 1/4 turn.
- ~~center~~ index center .800" from back face of fixture, lock Y axis.
- Place 3/4" ball nose 2 flute end mill in collet.

- Set cutting level .081" below top surface of fixture.
- Set RPM in Hi Range 2200 RPM and feed rate at 2.2.
- ~~Set~~ Mill the ten parts.
- air blow off parts.
- Remove fixture from vise.
- deburr holes with deburring tool while in fixture
- air blow again then remove washers from fixture.
- air blow fixture and vise and repeat deburr and filling fixture etc.
- deburr edges of washer after milling.

Note: removal of washers from fixture can be done with a $\frac{1}{4}$ " rod placed in the center of the washer then tilted.

Note: some washer will not have bore all the way thru, this is O.K. as the mill will machine down far enough to complete bore.





Aero Design Ltd.

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AMF 73-04

Nomenclature: CURVED WASHER QTY 235

Manufacturer: AERO DESIGN LTD.

Part No.: 95228-01 Serial / Batch No.: PO 15048

TTSN: N/A TSO: N/A Rem.: N/A

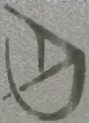
Work Order No.: 2016-14

Remaining Tasks to be Performed: NONE

Signature: [Signature]

Date: 18 Jan 16 Lic. No. / ACA AD01

Serviceable



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AMF 73-04

Remarks

Serviceable

Blank lined paper.